

Work Order ID 87067***87067***

July-10-12 2:49:15 PM

Item ID: D412-742-043
 Revision ID:
 Item Name: Replacement Float Skidtube

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Start Date: 8/06/12 Start Qty: 1.00

1

Cust Item ID:

Customer:

Work Order ID 87067***87067***

July-10-12 2:49:15 PM

Item ID: D412-742-043
 Revision ID:
 Item Name: Replacement Float Skidtube

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Start Date: 8/06/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/06/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: R Date: 12-07-11 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3391	I

100	DOCUMENT CONTROL	0.00
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100

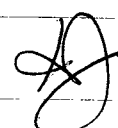
DC

Document Control

Memo

0.00

If D412-742-043 is a W/O on it's own,
 Photocopy bluefile and create labels per PPP D412-742-043 CHG005

N/A 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QAWCRWO RevE

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QAWCRWO RevE

Picklist Print

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Page 1

Work Order ID: 87067

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 8/06/12

Required Date: 8/06/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A 05.10.13 New Issue KJ/JLM
 IPP Rev 06.02.13 ECN 773 dwg @ rev.D EC
 IPP Rev:C 07-05-28 As per Rev F JLM
 IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM
 IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC IPP Rev:F 11.11.01 as per DSI9517
 REV.B DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3391-021 Fwd Tube Assembly		Manufactured	No			110	Each	0.0000					
D3391-023 Mid Tube Assembly		Manufactured	No			110	Each	2.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP		3							
				83625		1							
				GA		-1							
				85163		1							
D3391-025 Aft Tube Assembly		Manufactured	No			110	Each	2.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP001		2							
				84702		1							
				86183		1							
AN3C4A BOLT		Purchased	No			110	Each	3,664.0000	24				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST350		3664							
				120187		31							
				120521		28							
				120769		38							
				121205		67							
				121556		8							
				122151		3492							

1383637 (x1) JH 12/10/02

1385172 (x1) JH 12/10/02

1388101 (x1) JH 12/10/02

24 JH 24 12/10/02

M122814 x24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Work Order ID: 87067

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 8/06/12

Required Date: 8/06/12

Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No

110 Each 269.0000 10

10 12/10/02

BOLT

Location Loc Qty Loc Code

FP001 1

111982 1

ST351 268

111982 2

116419 23

116549 2

116704 12

117619 10

117688 1

117872 5

118422 13

119449 21

120423 3

120693 118

121682 58

11122416

X10

AN3C7A Purchased No

110 Each 184.0000 4

4 11/10/02

BOLT

Location Loc Qty Loc Code

ST351 184

113149 14

116169 1

117313 10

117619 12

117688 6

119749 1

120731 8

121185 30

121541 2

122141 100

X3

X1

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Page 3

Work Order ID: 87067

Parent Item: D412-742-043


Start Date: 8/06/12

Required Date: 8/06/12

Parent Item Name: Replacement Float Skidtube

Start Qty: 1.00

Required Qty: 1.00

AN960C10L washer  NAS1149C0332R Purchased No

110 Each 21.0000 38

38 11/10/12

Location

Loc Qty

Loc Code

ST 107534

21 21 122493

238

D4095-041 Manufactured No
Wearplate Assembly

110 Each 9.0000

1 11/10/12

Location

Loc Qty

Loc Code

FP001 83809 85616

9 7 2

D4095-043 Manufactured No
Wearplate Assembly

110 Each 16.0000

1 11/10/12

Location

Loc Qty

Loc Code

FP001 83479 85615

16 7 9

1305843

D4095-045 Manufactured No
Wearplate Assembly

110 Each 13.0000

1 11/10/13

Location

Loc Qty

Loc Code

FP001 77737 84081 85614

13 1 4 8

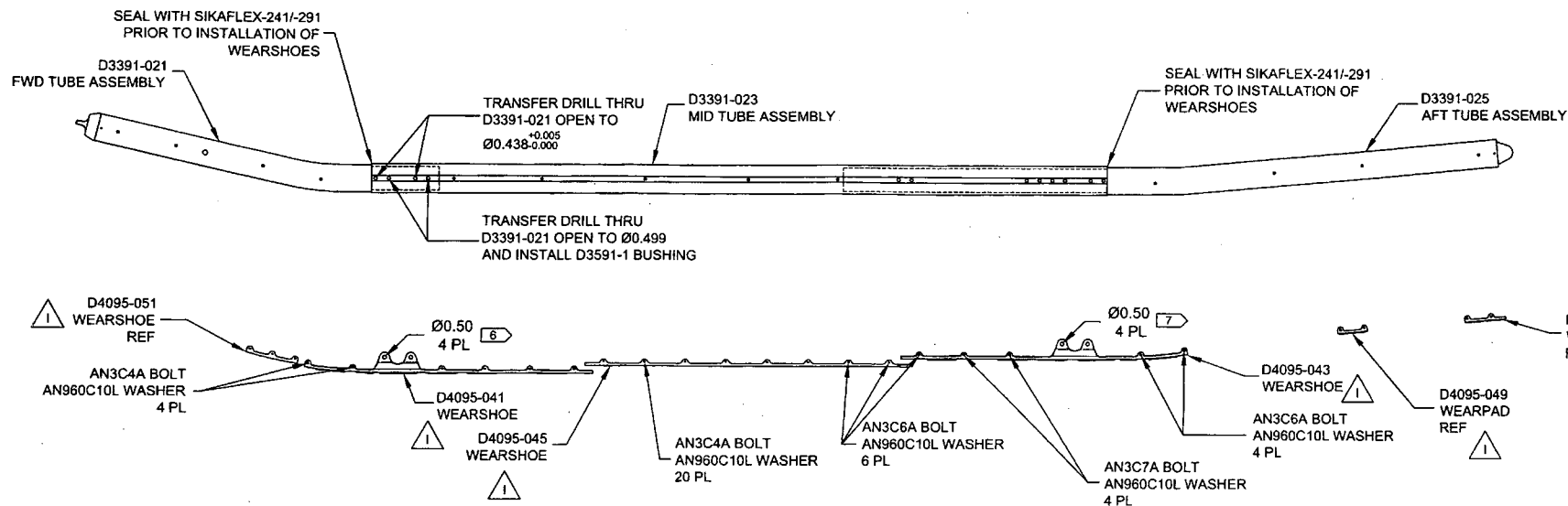
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -043	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARSHOE
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

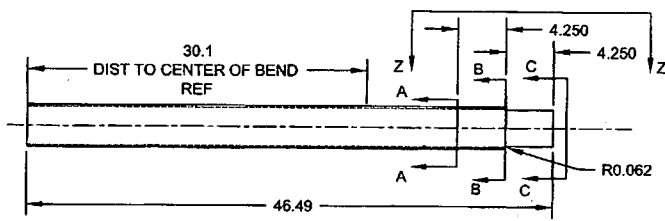
GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

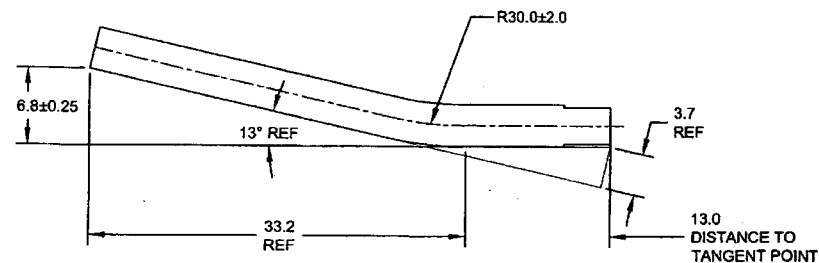
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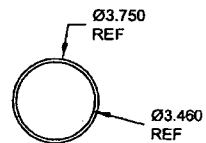
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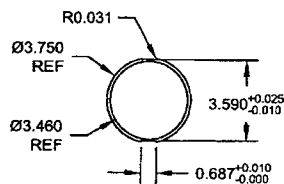
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



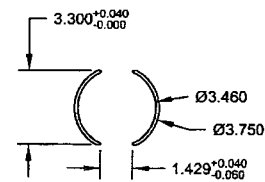
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



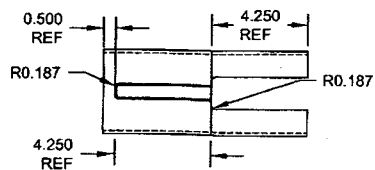
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SECTION B-B
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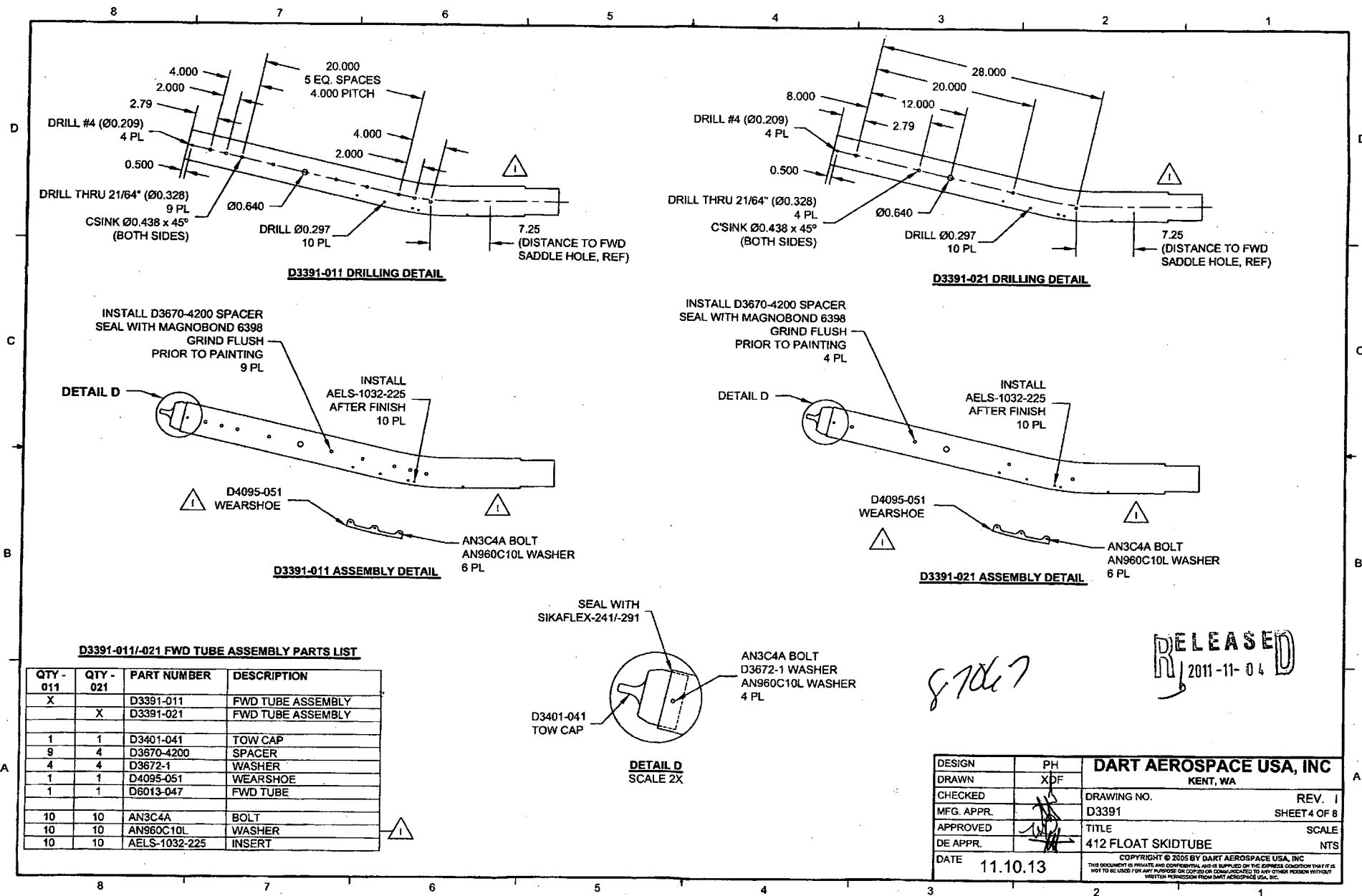
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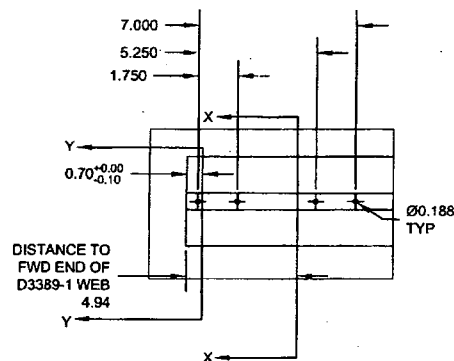


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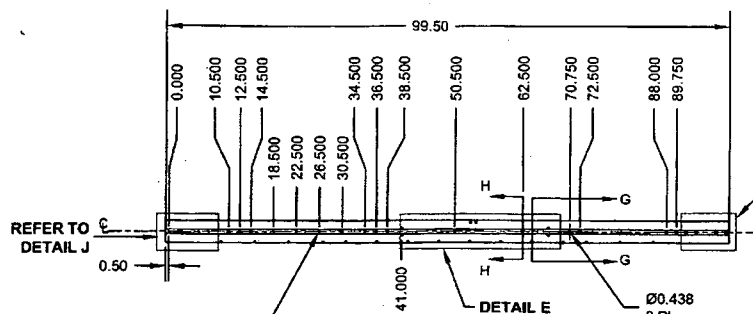
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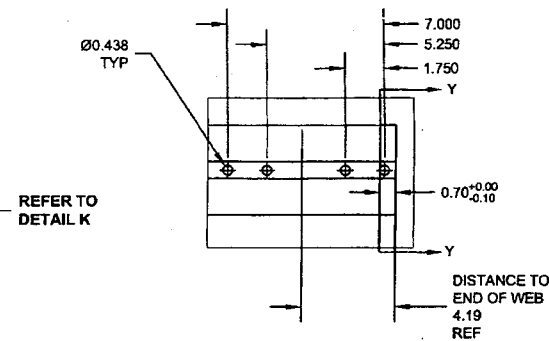




DETAIL J
SCALE 4X



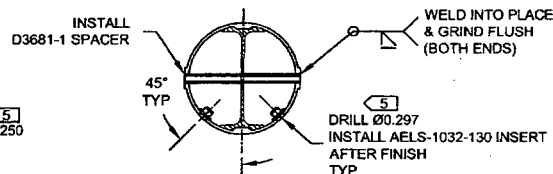
D3391-013 ASSEMBLY DETAIL
SCALE 5X



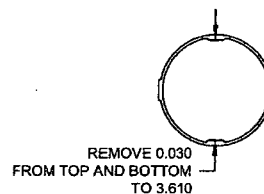
DETAIL K
SCALE 4X



SECTION G-G
SCALE 5X

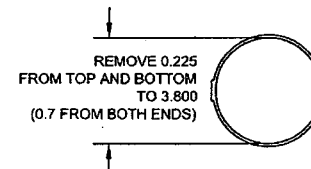


SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X

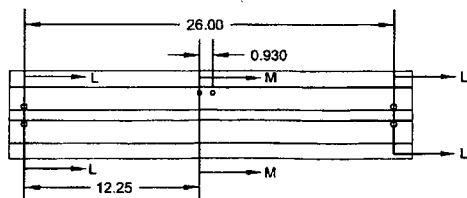
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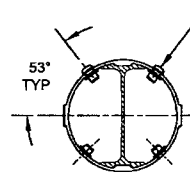
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D3391-013 MID TUBE ASSEMBLY PARTS LIST

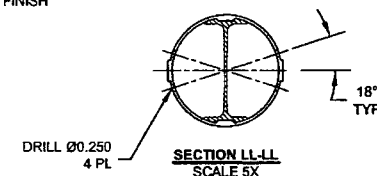
QTY	PART NUMBER	DESCRIPTION
-013		
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



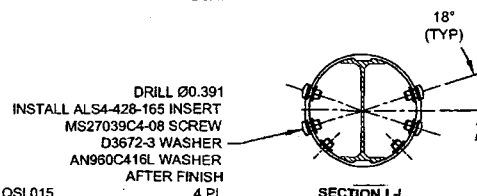
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SECTION M-M
SCALE 5X



SECTION LL-LL
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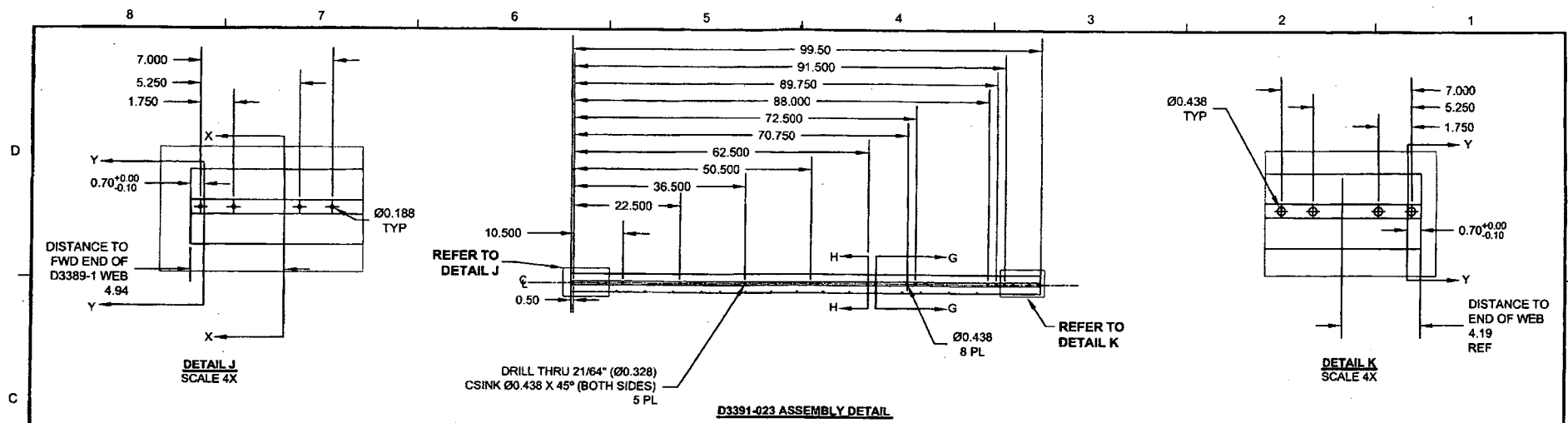


SECTION L-L
SCALE 5X

D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

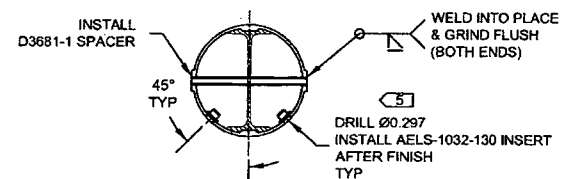
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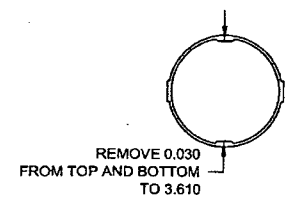
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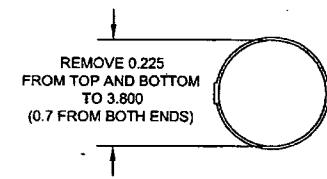
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SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



SECTION Y-Y
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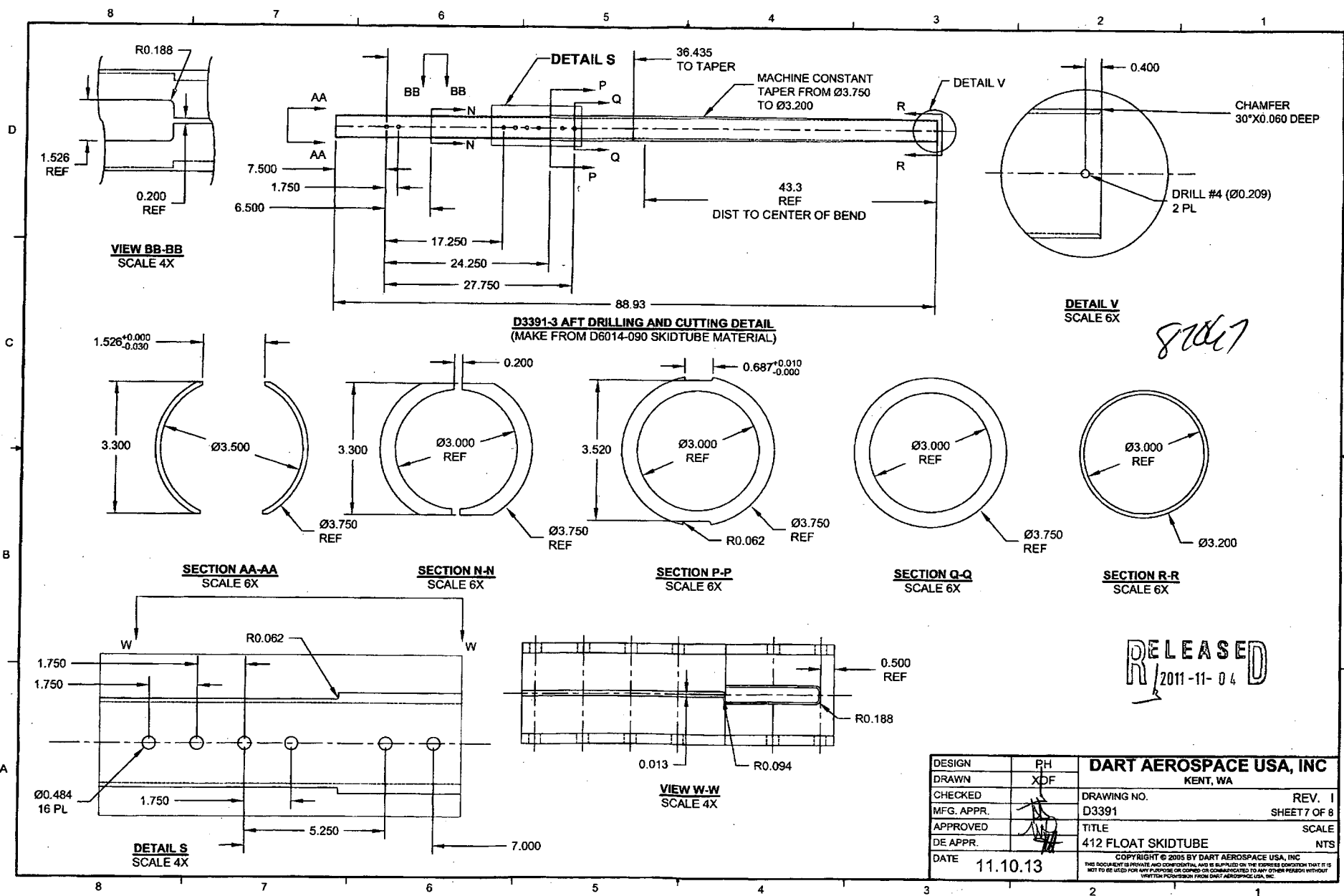
D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

- D3391-023 MID TUBE ASSEMBLY**
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
 - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
 - 3) WELDING: PER DART QSI 004

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2011-11-04

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